

13

Date: Thursday, 3/13/2008 1:01:32 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B AFT X-TUBE
Job Number : 37984
Estimate Number : 13221
P.O. Number :
This Issue : 3/13/2008 S.O. No. :
Prsht Rev. : NC Part Number : D206667201TRN
First Issue : / / Type : LANDING GEAR Drawing Number : D206-667-241 REVB
Previous Run : Project Number : N/A
Material :
Due Date : 3/28/2008 Qty: 1 Um: Each
Written By :
Checked & Approved By : 08 03 13
Comment : Est Rev: A 08-03-06 new issue DD verified by: ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6003102 Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch
1 D6003-102 Crosstube B29116

Check OD = 2.250"; ID = 1.380"

SG 08.04.03

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084

2-Turn first side as per Folio FA084

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

SG 08.04.03 (1)

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SG 08.04.03

(1)

4.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA084

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-241.

3-Remove sand and plugs

SG 08.04.03

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 1:01:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B AFT X-TUBE

Job Number: 37984

Part Number: D206667201TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-241
Inside of Cuff(Donot engrave on outside of tube)

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

08-04-03

(1)

6.0

QC8

SECOND CHECK



AWM 8-4-3



Comment: SECOND CHECK

08/04/03

(4)

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

N/A 08/04/07

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/04/04 (X1)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25 08-04-07

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in kanban rack

Location: X-tube can ban (turn)

25 08-04-07

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



mf 08-04-08

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 37984
Description: Crosstube Assembly		Part Number: D206-667-241
Inspection Dwg: D206-667-241 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	30° x 0.500	+/-0.010	.500	✓			
	0.250	+/-0.010	.250	✓			
	2.240	+0.005/-0.000	2.2414	✓			
	4.438	+/-0.030	4.438	✓			
	1.780	+0.005/-0.000	1.785	✓			
	R0.063	+/-0.010	R2.063	✓			
	1.851	+0.005/-0.000	1.853	✓			
	1.928	+0.005/-0.000	1.931	✓			
	2.005	+0.005/-0.000	2.007	✓			
	2.082	+0.005/-0.000	2.085	✓			
	2.159	+0.005/-0.000	2.162	✓			
	2.190	+0.005/-0.000	2.193	✓			
SIDE B	30° x 0.500	+/-0.010	.500	✓			
	0.250	+/-0.010	.250	✓			
	2.240	+0.005/-0.000	2.244	✓			
	4.438	+/-0.030	4.438	✓			
	1.780	+0.005/-0.000	1.785	✓			
	R0.063	+/-0.010	R2.063	✓			
	1.851	+0.005/-0.000	1.853	✓			
	1.928	+0.005/-0.000	1.931	✓			
	2.005	+0.005/-0.000	2.007	✓			
	2.082	+0.005/-0.000	2.084	✓			
	2.159	+0.005/-0.000	2.162	✓			
	2.190	+0.005/-0.000	2.192	✓			
	100.60	+/-0.020	100.60	✓			

Measured by: <i>BE</i>	Audited by: <i>AWM</i>	Prototype Approval:	N/A
Date: 08.04.03	Date: 08/04/03	Date:	N/A

Rev.	Date	Change	Revised by	Approved
A	06.10.16	New Issue (P/O D206-667-201)	KJ/JLM	<i>BE</i>



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-667-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (206B HIGH AFT) SCALE NTS	
A	00.11.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-06-16 [Signature]

Qty	Part Number	Description
X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
1	D6003-102	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
4	MS21920-20	CLAMP

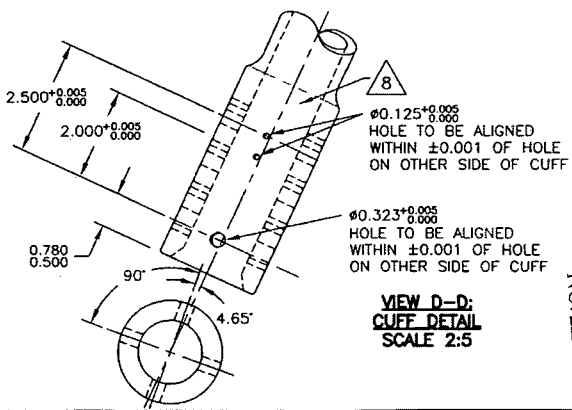
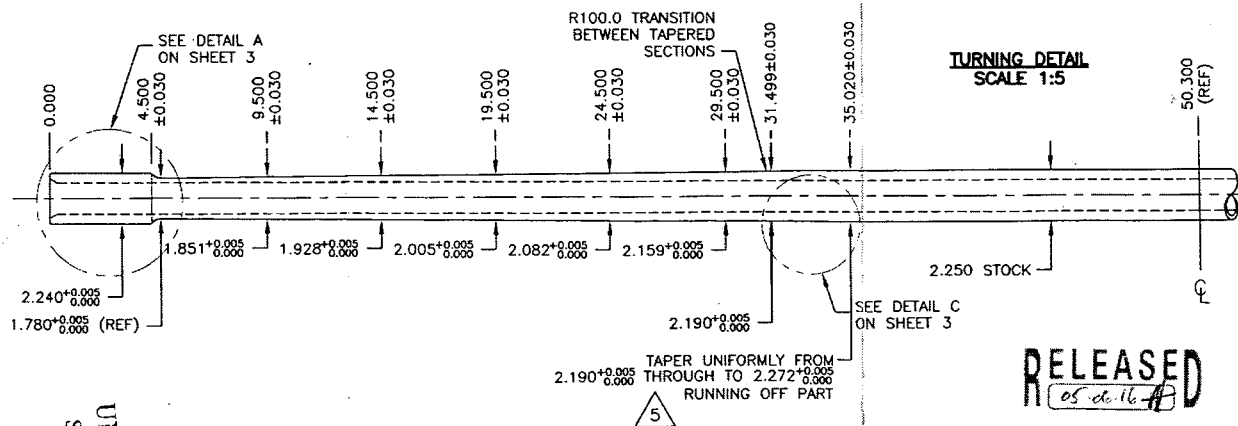
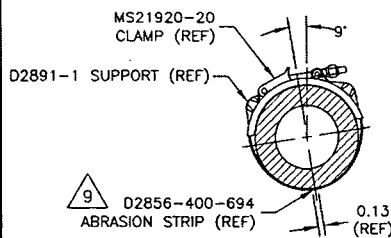
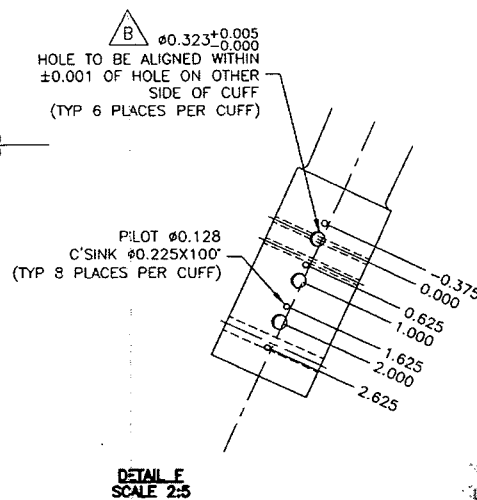
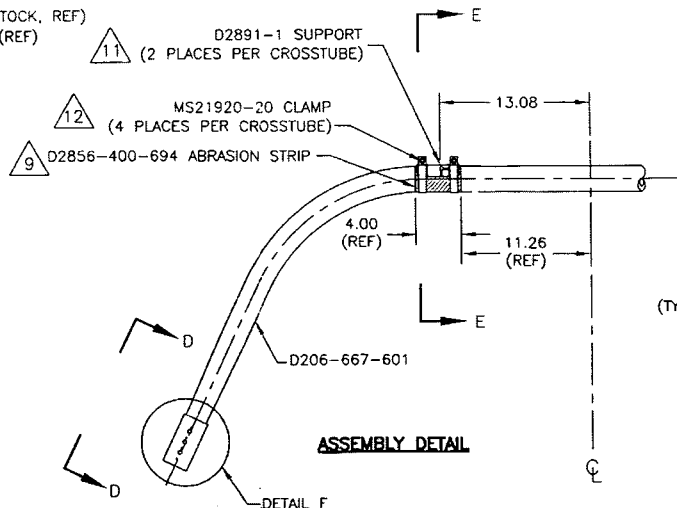
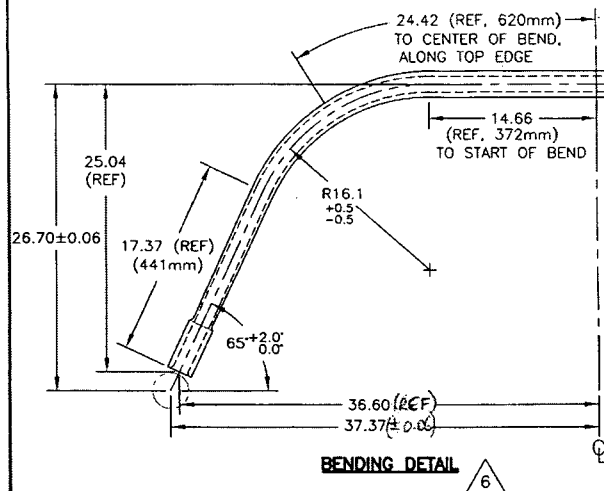
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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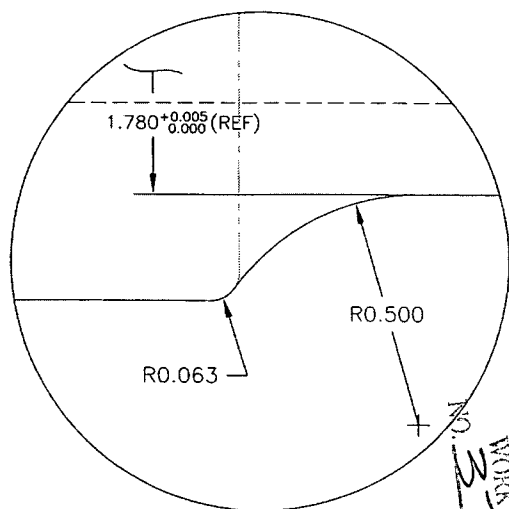
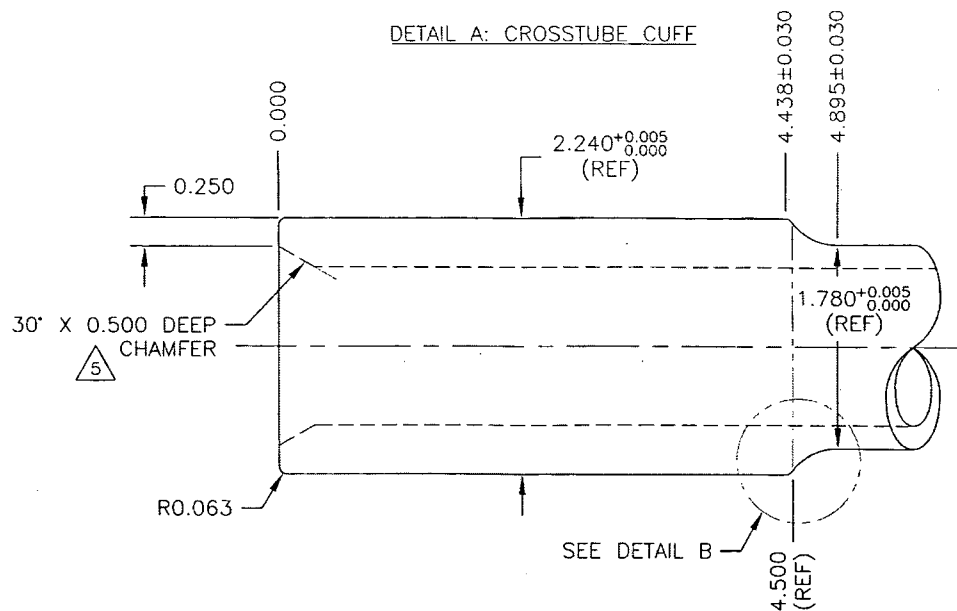
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DATE	05.02.04	DRAWING NO.		D206-667-241	REV. B
		TITLE		CROSSTUBE ASS'Y (206B HIGH AFT)	SHEET 2 OF 3
					SCALE 1:10

RELEASED
 05.06.16

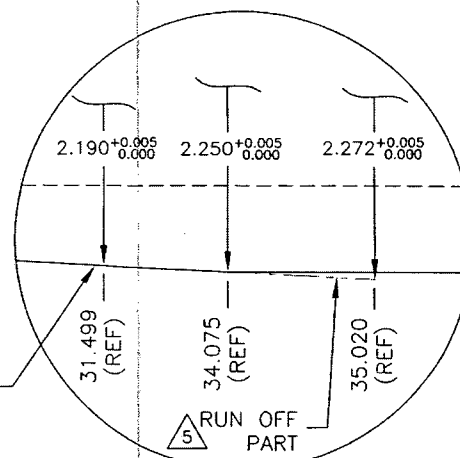
RELEASED
05-06-16

DETAIL A: CROSSTUBE_CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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CHECKED	#	APPROVED	#	DRAWING NO.	D206-667-241
DATE	05.02.04	TITLE	CROSSTUBE ASS'Y (206B HIGH AFT)	REV. B	SHEET 3 OF 3
		SCALE	1:1		